

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017427**Date Inspected:** 17-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (11AW-11BW)

The QA inspector observed the welding operation per the SMAW process on weld joint no. 003 in the (4G) overhead position on bottom panel piece mark no. OBW11B. The location was the transverse splice weld joining segment 11AW and segment 11BW. The welder ID was 040656. The ZPMC CWI was identified as Li Yang. The welding was performed against critical welding repair report B-CWR2052. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (11AW-11BW)

The QA inspector observed the welding operation per the SMAW process on weld joint no. 002 in the (4G) overhead position on side panel piece mark no. OBW11B. The location was the transverse splice weld joining segment 11AW and segment 11BW. The welder ID was 040656. The ZPMC CWI was identified as Li Yang. The welding was performed against welding repair report B-WR16012. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (11AW-11BW)

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The QA inspector observed the welding operation per the SMAW process on weld joint no. 011 and 043 in the (4G) overhead position on bottom panel to side panel piece mark numbers SEG065A and SEG067A. The location was the longitudinal weld on W3 work point joining bottom panel and side panel of segment 11AW and segment 11BW. The welder ID was 040611. The ZPMC CWI was identified as Li Yang. The welding was performed against welding repair report B-WR16026. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

For additional information please reference the pictures below:

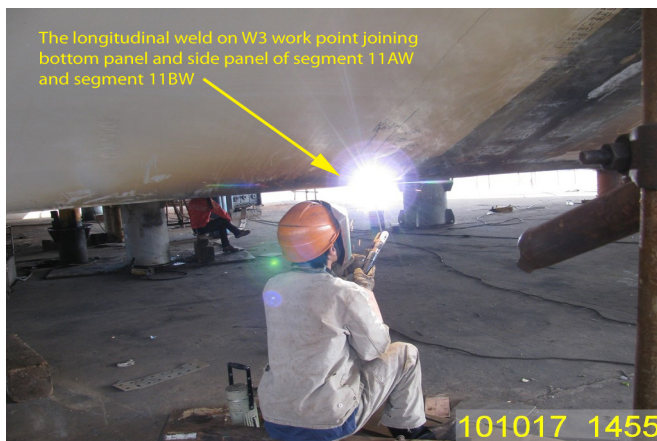
OBG # TRIAL ASSEMBLY YARD (11AW-11BW)

The QA inspector observed the welding operation per the SMAW process on weld joint no. 012 and 021 in the (4G) overhead position on bottom panel to side panel piece mark numbers SEG065A and SEG067A. The location was the longitudinal weld on W4 work point joining bottom panel and side panel of segment 11AW and segment 11BW. The welder ID was 040656. The ZPMC CWI was identified as Li Yang. The welding was performed against welding repair report B-WR16025. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (11AE-11BE)

The QA inspector observed the welding operation per the SMAW process on weld joint no. 014 in the (4G) overhead position on bottom panel to side panel piece mark no. SEG066A. The location was the longitudinal weld on E3 work point joining bottom panel and side panel of segment 11AE and segment 11BE. The welder ID was 044515. The ZPMC CWI was identified as Li Yang. The welding was performed against critical welding repair report B-CWR2044. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
